(C) SCALE: 2=1 DWG. SCALE:.5 A2336200 3 2 D D 3x #4-40 TAP x .23 [5.84] DP .750 [19.05] 4x #4-40 TAP THRU [e,.001,A] <del>- 0 0 0 0</del> -2x Ø0937 [2388] (PRESS FIT) | h | .001 | A | C C [f,.001] [-A-] Ø100 [2.54] #10-32 TAP THRU В В NOTES: 1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV) WHEN MACHINING VACUUM PARTS, USE SILICONE
AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED.
USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL 3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN. A2336200 4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL. J.GOGOL 9/14/9 5. DIMENSIONS IN [ ] ARE MILLIMETERS AND Α Α X1-84 2D CRYSTAL HOLDER FOR 3-ID-A KOHZU ADJUSTMENT PLATE (LONG) FOR REF. ONLY 6. SURFACE ROUGHNESS 63/ J.GOGOL 9/14/9 C P4105091103-840002-00 CARPENTER STL (39% NICKEL) 3 4